

Work Order ID 70824

Wednesday, June 15, 2011 2:29:05 PM



Page 1

Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: P

Date: 11-06-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

8/10/17

Clear CL 11-6-17

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 4104929

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: 4114596

4/31/06/17 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70824

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Page 2

Item ID: D412-630-033

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Stop



Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8/16/17



QC

Memo

0.00

Quality Control



130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/17 SP/2

140

QC4- 100% Inspect kits for completeness

0.00

8/16/17

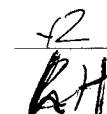


QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70824

Wednesday, June 15, 2011 2:29:05 PM



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Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033 Location: _____ PPP Rev: <u>A</u>								
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/11 2 (2)

11/6/22

MF
11-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, June 15, 2011 2:29:12 PM

Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding




Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107  Clevis		Manufactured	No			110	Each	21.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				21					
				66811				21					
D2803-041  Bracket Assembly		Manufactured	No			110	Each	4.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST149				4					
				61724				3					
				64092				1					
D2804-041  Bracket Assembly		Manufactured	No			110	Each	3.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST150				3					
				61726				3					

BG2075 (200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, June 15, 2011 2:29:13 PM

Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

D2807-041



Door prop

Manufactured No

110 Each

25.0000

2

4



EP 11/06/17

Location

Loc Qty

Loc Code

ST022

25

60540

2

66336

3

69671

20

4 4

D2813



Washer

Manufactured No

110 Each

26.0000

2

4



EP 11/06/17

Location

Loc Qty

Loc Code

ST023

26

61051

5

69386

21

1 3

D3562-041



Step Assembly, LH

Manufactured No

110 Each

1.0000

1

2



EP 11/06/17

Location

Loc Qty

Loc Code

FG110

1

54963

1

B69398 (2x)

D3395-1



Bushing

Manufactured No

110 Each

36.0000

4

8



EP 11/06/17

Location

Loc Qty

Loc Code

ST052

36

68491

6

69387

30

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C21A

Purchased

No

110

Each

85.0000

2

4



BOLT

Location

Loc Qty

Loc Code

ST352

85

109148

15

117366

20

117514

50



EP 11/06/17

4

AN8C16

Purchased

No

110

Each

45.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST345

45

106066

45



EP 11/06/17

4

AN310C8

Purchased

No

110

Each

31.0000

2

4



Nut

Location

Loc Qty

Loc Code

ST324

31

111819

1

117771

30



EP 11/06/17

4

MS24665-302

Purchased

No

110

Each

192.0000

6

12



Cotter Pin

Location

Loc Qty

Loc Code

ST357

192

117460

192



EP 11/06/17

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist-Print

Wednesday, June 15, 2011 2:29:13 PM

Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased

No

110

Each

132.0000

4

8



Washer

Location

Loc Qty

Loc Code

ST277

132

116373

32

117460

100

6
6

NAS1515H5L

Purchased

No

110

Each

84.0000

4

8



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

44

111359

44

8

NAS1515H8

Purchased

No

110

Each

243.0000

4

8



Washer

Location

Loc Qty

Loc Code

ST278

243

111275

43

111411

200

8

MS21043-3

Purchased

No

110

Each

283.0000

4

8



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

211

112314

211

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 15, 2011 2:29:14 PM

Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

MS24693-C280

Purchased

No

110

Each

19.0000

2

4



Screw

Location

Loc Qty

Loc Code

ST310

18

115594

18

ST318

1

111279

1

D2806-1

Manufactured

No

130

Each

22.0000

2

4



Bushing

Location

Loc Qty

Loc Code

ST022

22

64074

2

68492

20

D2806-3

Manufactured

No

130

Each

23.0000

2

4



Bushing

Location

Loc Qty

Loc Code

ST022

23

64075

3

69401

20

D2810-5

Manufactured

No

130

Each

16.0000

1

2



Strut

Location

Loc Qty

Loc Code

ST265

16

52034

1

68493

5

69402

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, June 15, 2011 2:29:14 PM

Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

D3396-1

Manufactured No

130 Each

24.0000

2



Spacer

Location

Loc Qty

Loc Code

ST052

24

46748

24

Purchased

No

130 Each

330.0000

1

AN4C6A



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

276

116704

1

117619

150

117794

50

117872

75

Purchased

No

130 Each

81.0000

1

AN4C10A



Bolt

Location

Loc Qty

Loc Code

ST356

81

111295

4

112243

47

114528

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist-Print

Wednesday, June 15, 2011 2:29:14 PM

Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

AN5C15A

Purchased

No

130

Each

73.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST339

73

111819

23

~~117764~~

25

117885

25

AN44C7A

Purchased

No

130

Each

73.0000

1

2



Eyebolt

Location

Loc Qty

Loc Code

ST362

73

109013

33

~~111308~~

40

AN4C15A

Purchased

No

130

Each

125.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST358

125

115835

25

~~113936~~

2

117441

48

117795

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist-Print

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Wednesday, June 15, 2011 2:29:15 PM

Work Order ID: 70824

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H4

Purchased

No

130

Each

188.0000

7

'14



Washer

Location

Loc Qty

Loc Code

ST277

188

111525

2

116169

36

117460

50

117735

100

NAS1515H5

Purchased

No

130

Each

123.0000

7

14



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

83

109430

83

MS21043-4

Purchased

No

130

Each

1,147.000

4

8



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

107

117423

107

ST301

1000

117601

500

117793

500

Wednesday, June 15, 2011 2:29:15 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Wednesday, June 15, 2011 2:29:15 PM

Work Order ID: 70824



Parent Item: D412-630-033



Parent Item Name: Heli Access Step LH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-5

Purchased

No

130

Each

511.0000

3

6



Nut



11/6/11 JSP (2)

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

491

112314

391

116548

100

6

Wednesday, June 15, 2011 2:29:15 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

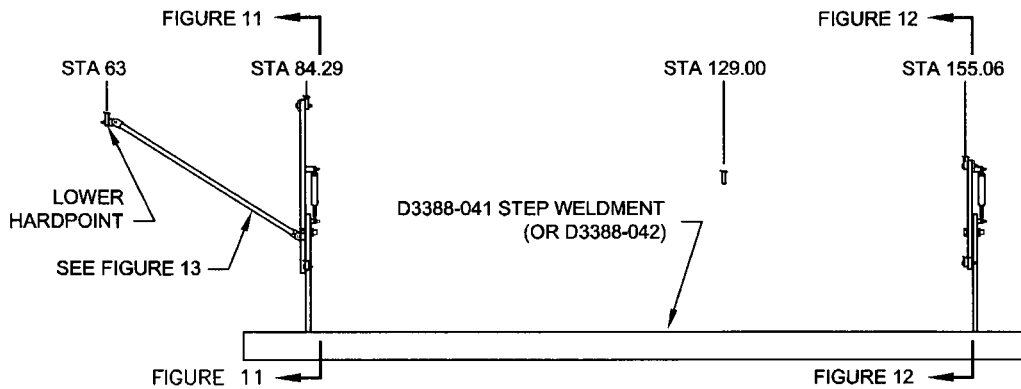
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

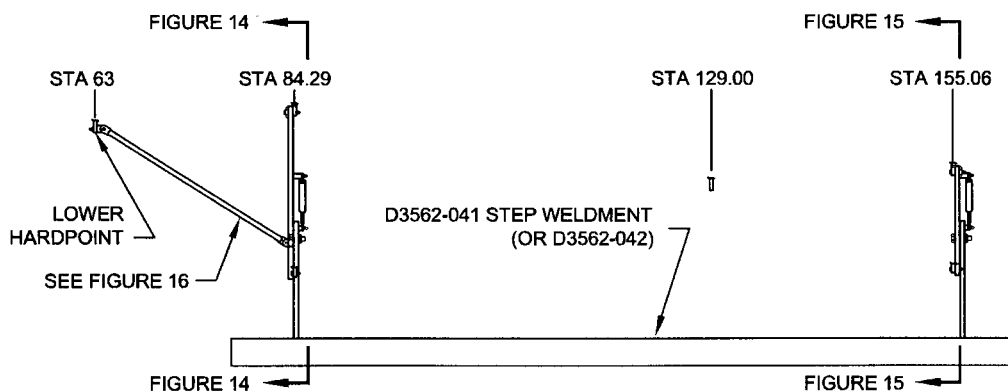
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

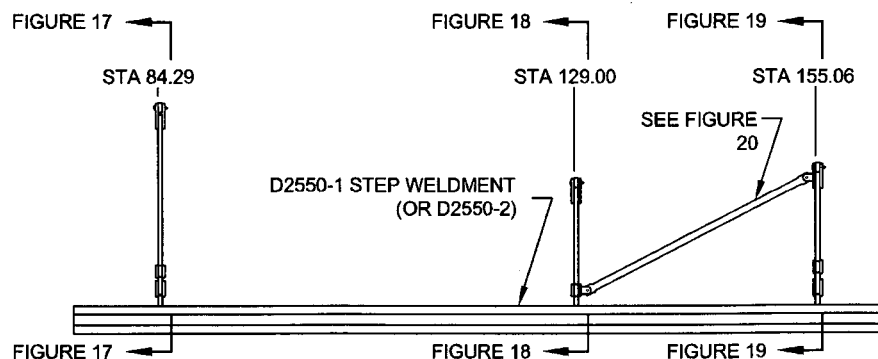
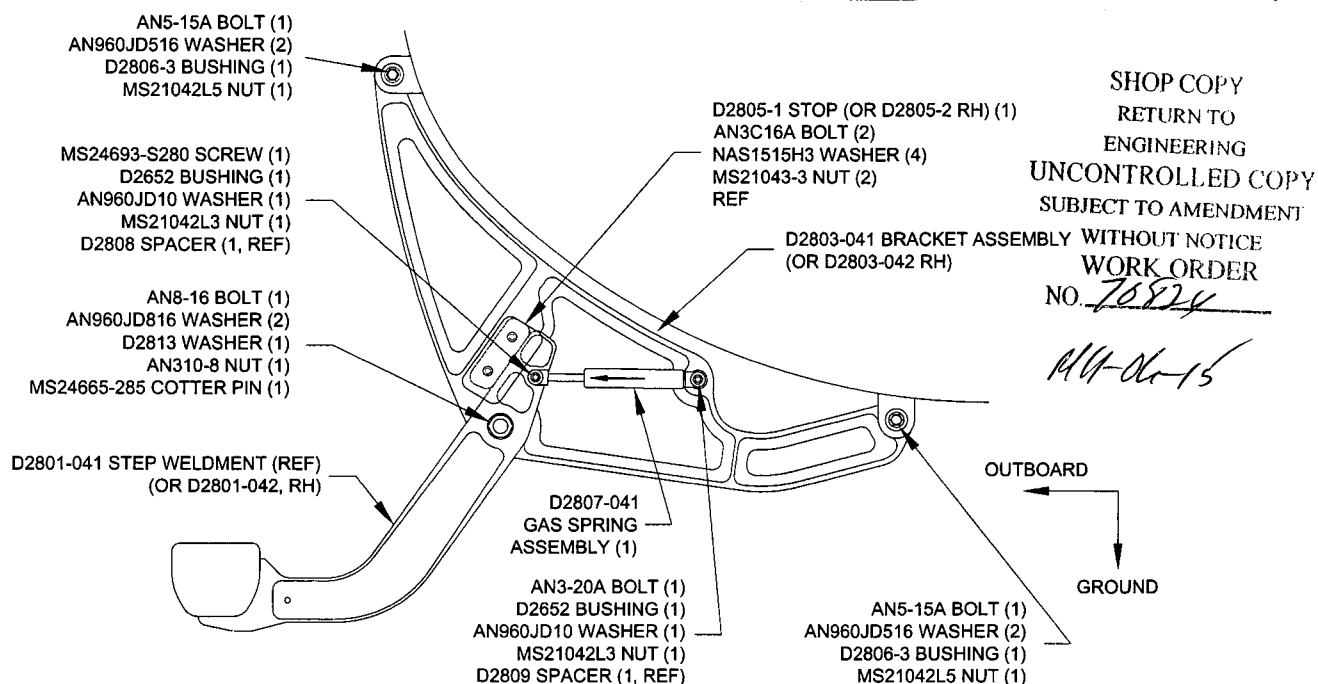
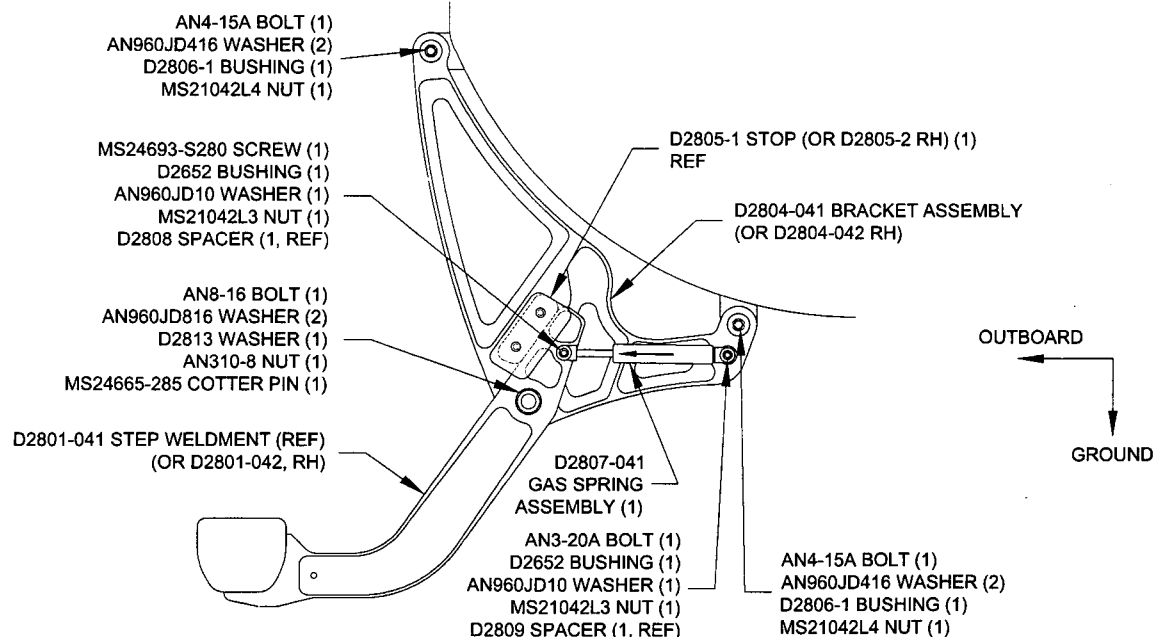


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
 Date: 08.12.12

D412-630-013/-014 Heli-Access-Step™ Installation**FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **M**
Date: 08.12.12

Dart Aerospace Ltd

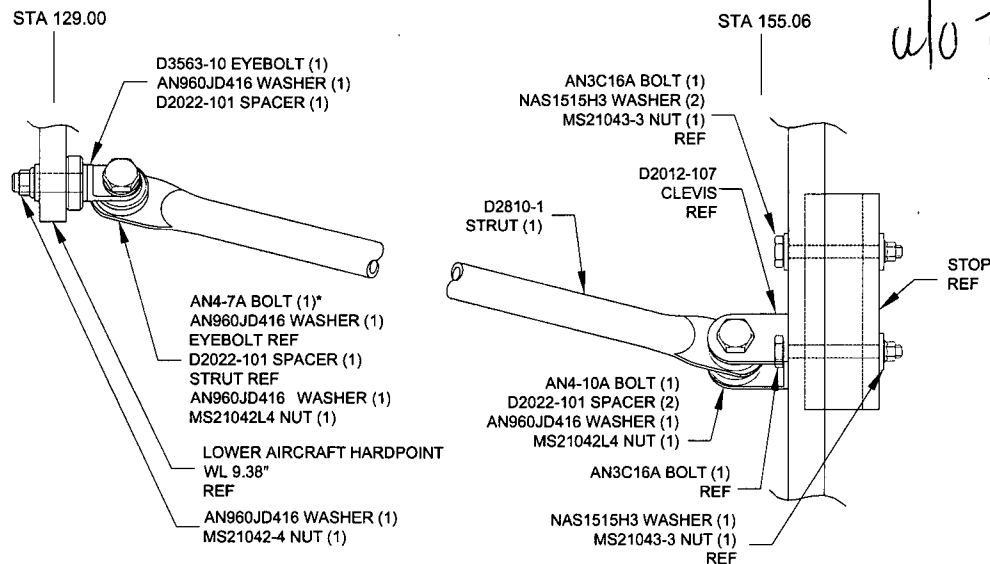
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



* IF ADJUSTMENT OF THE STRUT IS REQUIRED TO AVOID OTHER HARDWARE ON THE AIRCRAFT, IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND ADDITIONAL WASHERS AS REQUIRED TO ADJUST THE ATTACHMENT OF THE D2810-1 STRUT TO THE EYEBOLT.

FIGURE 10 – Strut Detail for D412-630-013/-014 Heli-Access-Step™ Installation (NOT TO SCALE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)